

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D205-634 REV. G AND D204-635 REV. G OR EARLIER, AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-634 REV. 4 AND D204-635 REV. 4 OR EARLIER
REF CANADIAN STC: SH96-88
REF FAA STC: SR00563NY
REF EASA STC: EASA.IM.R.S.01303

1.0 PURPOSE:

To provide a repair for cracked D2579 saddle spacers in early model D205-634-011 and D204-635-011 skidtubes.

2.0 PROCEDURE:

1) Remove the affected skidtube(s) in accordance with ICA-D205-634 / ICA-D204-635 Chapter 32.1. Place on a suitable work surface and remove aft cap(s) in accordance with ICA-D205-634 / ICA-D204-635 Chapter 32.8.

2) Remove paint, old sealant, etc in the affected area.

3) Slowly drill out one side of the damaged spacer(s) to Ø 0.500" using the provided step drill while ensuring not to flare the end of the spacer. Slowly drill out the other side, then deburr holes to remove all sharp edges.

Note: The spacer will be pushed slightly out of the skidtube by the step drill once the final side is drilled out.

4) Chamfer spacer holes to 0.050" X 45° on both sides of the skidtube.

5) Touch up holes with chemical conversion coating in accordance with MIL-DTL-5541.

6) Install D4981-1 spacer using Magnobond 6398 or ProSeal 890 (Ref. AMS-S-8802), allow adequate time for sealant to cure, and grind flush.

7) Touch up finish with one coat of MIL-P-85582 or MIL-P-23377 primer, and 2-3 coats of MIL-C-83285 Polyurethane paint to match original finish as required.

8) Remove all swarf from the interior of the skidtube and reinstall aft cap in accordance with ICA-D205-634 / ICA-D204-635 Chapter 32.8. Reinstall skidtube(s) on aircraft per ICA-D205-634 / ICA-D204-635 Chapter 32.2.

3.0 PARTS LIST:

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9675-011	CROSSBOLT SPACER REPAIR KIT
8	D4981-1	SPACER
1	IRWIN 1T UNIBIT	STEP DRILL

4.0 WEIGHT AND BALANCE:



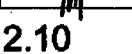
There is a negligible weight and balance change associated with this modification.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 13.12.15
CERT. NO.: SH96-88
ISSUE NO.: 3

B	REVISED PROCEDURE	ML	13.12.10
A	NEW ISSUE	ML	13.11.18
REV.	DESCRIPTION	BY	DATE
DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		DSI 9675	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		SPACER REPAIR KIT	NTS
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